

5/18

DART AEROSPACE LTD	Work Order:	22939
Description: Pedal Lock Base	Part Number:	D3368-1
Dwg: D3368 Rev. A1 05.04.14	Qty:	25
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JL	05.04.07	25
2	MV	Cut blank: 2.00" x 2.00" x 10.450" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.000x02.000) Identify for D3368-1 Batch: M16764	J.L	05/04/14	25
3	MV	Machine D3368-1 as per Folio FA499 and Dwg D3368 Identify as D3368-1	J.L	05/04/15	25
4	QC2	Inspect parts as they come off the CNC machine	J.L	05/04/15	25
5	QC8	Second check	JL	05.04.15	25
6	MV	Deburr	JL	05/04/15	25
7	QC5	Inspect work to Step 6	JL	05.04.15	25
8	FP	Chemical Conversion Coat as per QSI 005 4.1	JL	05.04.15	25
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	JL	05.05.10	25
10	QC3	Inspect Powder Coat	SB	05/05/12	13
			CL	05/05/16	10
11	ST	Identify and Stock	CL	05/05/16	25
12	AC	Cost / part 21.11	AL	05/05/17	25
13	DC	Close W/O 23.13 Inspect Level 21	JL	05.05.24	25

Rev	Date	Change	Revised By	Approved
A	05.01.27	New issue	KJ/JLM	

RELEASED
05-0131

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. A SHEET 1 OF 3
DATE 05.01.19		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
A1	05.04.14	0.650 WAS 0.700 ; 1.450 WAS 1.250 0.300 WAS 0.313	

RELEASED
[Signature]

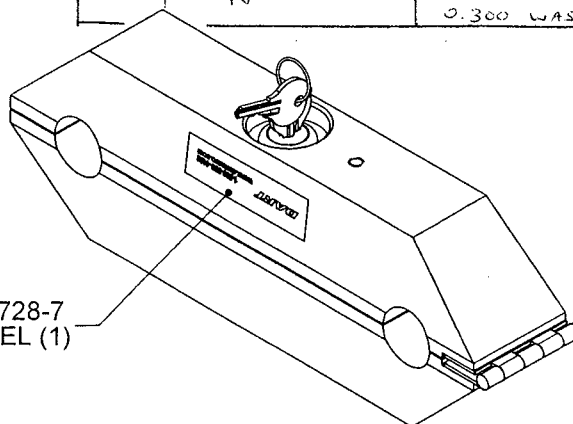
05/02/22

CANCEL ~~05.04.09~~

UNDER REVIEW

RF 05.03.22

WEIGHT REDUCTION
+ HINGE CHANGE



D2728-7
LABEL (1)

SHOP COPY

RETURN TO
ENGINEERING

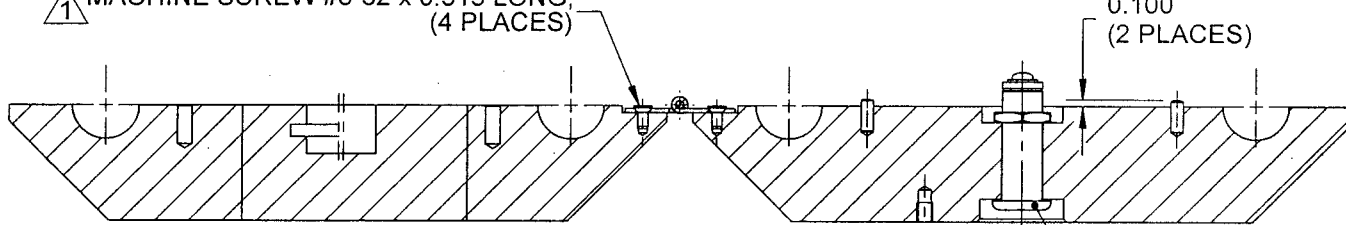
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WITHOUT NOTICE

WORK ORDER

NO. 22939

PEDAL LOCK SHOWN LOCKED WITH KEY

1 MACHINE SCREW #8-32 x 0.313 LONG,
(4 PLACES)

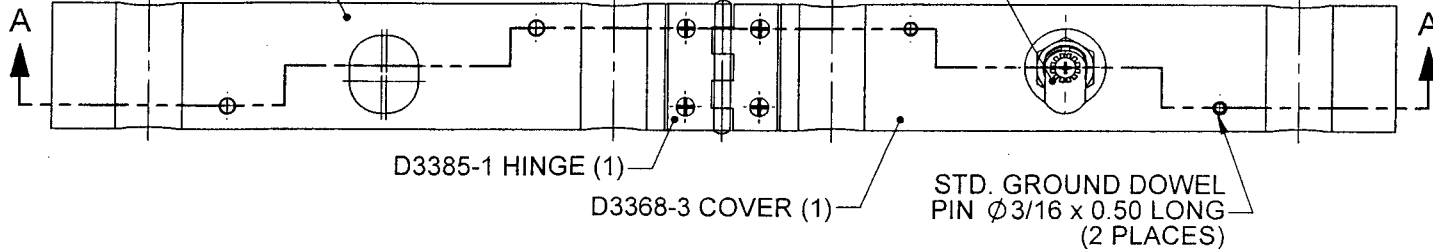


SECTION A-A

D3373-7 CAM
LOCK ASS'Y

D3368-1 BASE (1)

D3371-5 CAM (1),
SQUARE WASHER SPACER (1),
EXTERNAL TOOTH LOCK WASHER (1),
#10-32 UNF PAN CROSS HEAD SCREW (1),
(AS PER D3373-1)



D3385-1 HINGE (1)

D3368-3 COVER (1)

STD. GROUND DOWEL
PIN $\varnothing 3/16$ x 0.50 LONG
(2 PLACES)

D3368-051 PEDAL LOCK ASSEMBLY

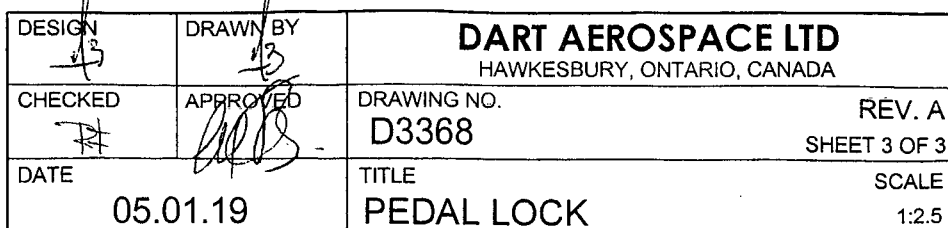
NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-039
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

PRELIMINARY ISSUE

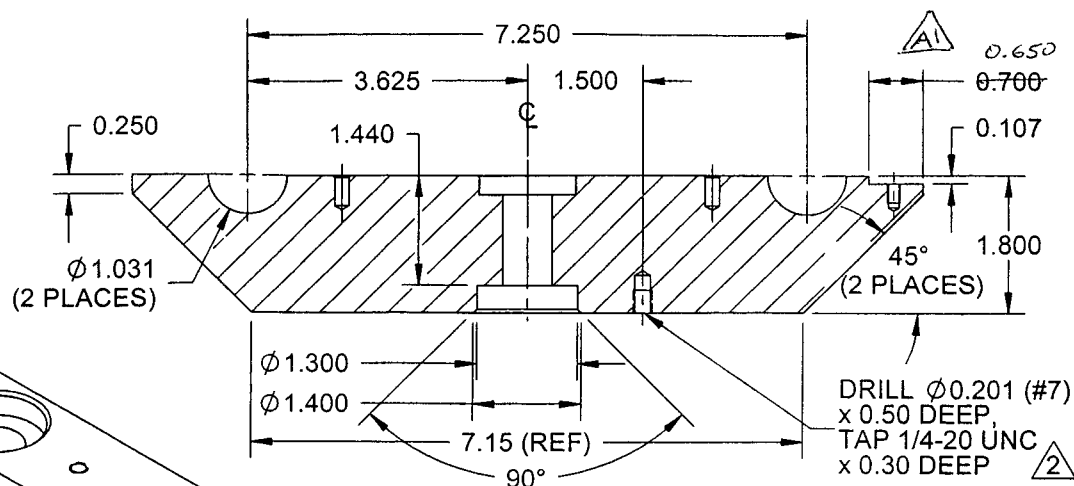
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05/02/22

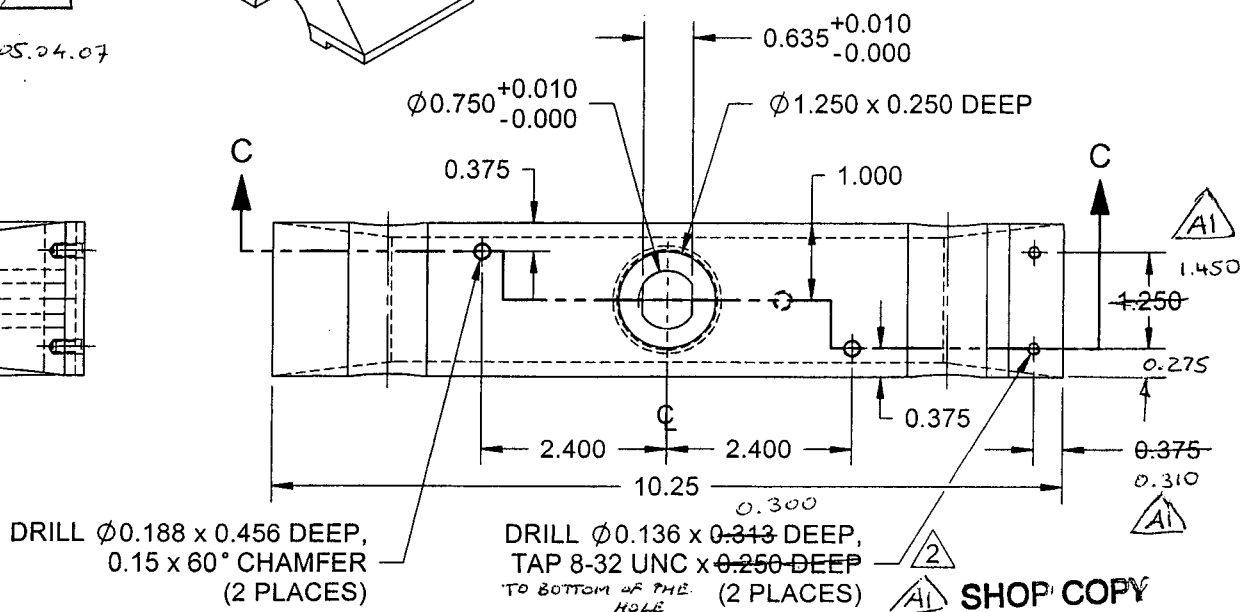
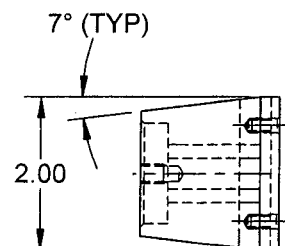


SECTION C-C

~~UNDER REVIEW~~

~~28.03.22~~

CANCEL ~~TR~~ 05.04.07



PRELIMINARY ISSUE

D3368-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

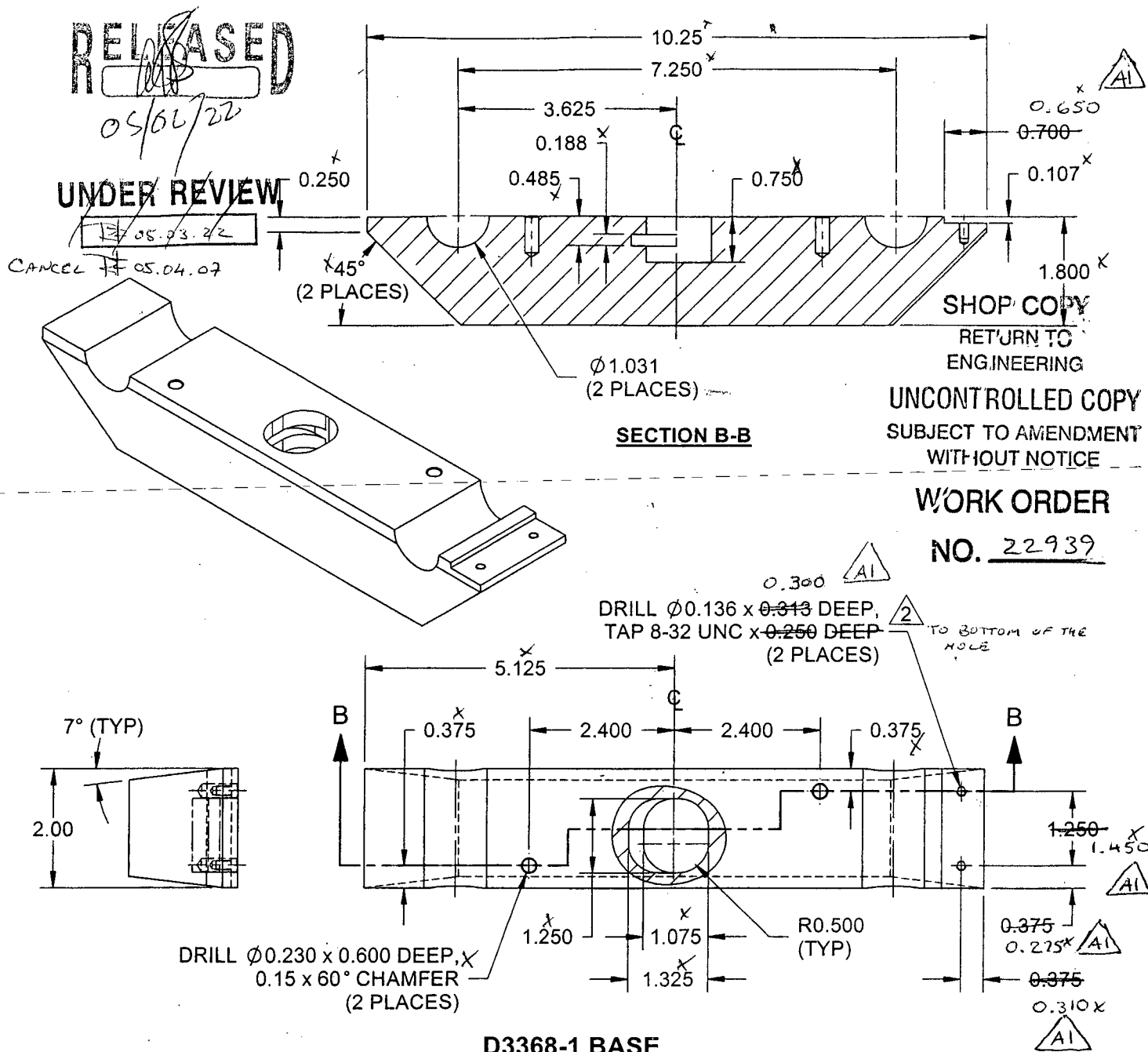
NO. 22939

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. A SHEET 2 OF 3
DATE 05.01.19	TITLE PEDAL LOCK	SCALE 1:2.5	



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

PRELIMINARY ISSUE

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 07, 2005
10:55 am

Work Order No : 0022939
Project Name : D3368-1
Project For : WK518
Work Order Type : Main
Main WO Number :
House Part Number : D3368-1
Description : Pedal Lock Base
Manufactured : Yes
Amount Req'd : 25
Amount Done : 0
Start Date : 04-07-05
Est Finish Date : 04-28-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DAK AEROSPACE LTD

Work Order: 22939

Description: pedal lock "base"

Part Number: A-3368-1

Inspection Draw: A3368

Rev: A1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	$\pm .030$	10.251	✓		h-gauge	
7.250	$\pm .010$	7.249	✓		vern	
.650	$\pm .010$.650	✓		vern	
.107	$\pm .010$.108	✓		vern	
1.800	±.799 $\pm .010$	1.799	✓		vern	
45°		✓	✓			
.750	$\pm .010$.752	✓		vern	
.250	$\pm .010$.250	✓		vern	
.485	$\pm .010$.484	✓		h-gauge	
.188	$\pm .010$.188	✓			
3.625	$\pm .010$					
2.00	$\pm .030$	1.992	✓		vern	
7°		✓	✓			
5.125	$\pm .010$	5.125	✓		h-gauge	
.375	$\pm .010$.371	✓		vern	
Ø.230x600 deep	$.230^{+.005}_{-.005}$.232 x .597 deep	✓		vern	
1.250	$\pm .010$	1.249	✓		vern	
1.075	$\pm .010$	1.074	✓		vern	
1.325	$\pm .010$					can't measure
.310	$\pm .010$.310	✓		vern	
.275	$\pm .010$.271	✓		vern	
1.450	$\pm .010$	1.448	✓		vern	
2.400	$\pm .010$	2.398	✓		h-gauge	

Measured by: J.L

Audited by: SA

Prototype Approval:

Date: 05/04/14

Date: 03.04.14

Date:

N/A

Rev Date Change
A New IssueRevised by Approved
KJ/JLM

DART AEROSPACE LTD		Work Order:	22939
Desc: 10301		Part Number:	D3368-1
Inspection Dwg	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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[illegible]

Measured by:	Audited by:	Prototype Approval:
Date:	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	